# ENVIRONMENTAL PRODUCT DECLARATION

as per *ISO 14025* and *EN 15804+A2*

| | |
|---|---|
| Owner of the Declaration | Sonae Arauco, S.A. |
| Publisher | Institut Bauen und Umwelt e.V. (IBU) |
| Programme holder | Institut Bauen und Umwelt e.V. (IBU) |
| Declaration number | EPD-SON-20230516-IBA2-EN |
| Issue date | 10.01.2024 |
| Valid to | 09.01.2029 |

## Particleboard, coated

## Sonae Arauco, S.A.

Institut Bauen und Umwelt e.V.

ECO PLATFORM EPD VERIFIED

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# 1. General Information

## Sonae Arauco, S.A.

**Programme holder**

IBU – Institut Bauen und Umwelt e.V.
Hegelplatz 1
10117 Berlin
Germany

**Declaration number**

EPD-SON-20230516-IBA2-EN

**This declaration is based on the product category rules:**

Wood-based panels, 01.08.2021
(PCR checked and approved by the SVR)

**Issue date**

10.01.2024

**Valid to**

09.01.2029

Dipl.-Ing. Hans Peters
(Chairman of Institut Bauen und Umwelt e.V.)

Florian Pronold
(Managing Director Institut Bauen und Umwelt e.V.)

## Particleboard, coated

**Owner of the declaration**

Sonae Arauco, S.A.
Calle Ulises 26-18
28043 Madrid
Spain

**Declared product / declared unit**

Particleboard, coated, per $m^2$

**Scope:**

This document refers toparticleboard, coated with melamine-impregnated paper, manufactured in the following plants of the Sonae Arauco group:

- Sonae Arauco Beeskow GmbH, Radinkendorfer Strasse 71, 15848 Beeskow, Germany
- Sonae Arauco Deutschland GmbH - Nettgau Plant, Strohmweg 1, 38489 Nettgau, Germany
- Sonae Arauco Portugal, SA, Estrada Nacional 17, nº 59 e 61, 3400-691 S.Paio de Gramaças (Oliveira do Hospital), Portugal
- Sonae Arauco South Africa (Pty) Ltd, Heidelberg Road, Rocky Drift, White River, Republic of South Africa
- Sonae Arauco España- Soluciones de Madera, S.L., Carretera Córdoba-Valencia Km 126, Estación Linares-Baeza, 23490 Linares (Jaén), Spain

The production volume of these plants covers 100 % of the total production of particleboard by the Sonae Arauco group.
The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

The EPD was created according to the specifications of EN 15804+A2. In the following, the standard will be simplified as *EN 15804*.

**Verification**

| | | | |
|---|---|---|---|
| The standard EN 15804 serves as the core PCR | | | |
| Independent verification of the declaration and data according to ISO 14025:2011 | | | |
| ☐ | internally | ☒ | externally |

Mr Olivier Muller,
(Independent verifier)

# 2. Product

## 2.1 Product description/Product definition

Coated particleboard is a panel-shaped wood-based material in accordance with *EN 312* and *EN 14322*, which is manufactured in a flat-pressing process by means of compression under heat of small wood particles with adhesive.
Due to their various densities and adhesive systems, coated particleboards can display a variety of material properties and qualities like moisture resistance, fire-retardant or others.
For the placing on the market of the product in the European Union/European Free Trade Association (EU/EFTA) (with the exception of Switzerland), *Regulation (EU) No. 305/2011 (CPR)* applies. When applicable, the product needs a declaration of performance taking into consideration *EN 13986:2004+A1:2015 Wood-based panels for use in cons*truction - Characteristics, evaluation of
conformity and marking and the CE marking.

For the application and use the respective national provisions apply.

## 2.2 Application

The area of application for coated particleboard primarily involves decorative interior furnishings and furniture manufacturing.
Particleboard can be classified into the following use classes according to the requirements
established in *EN 312*:

- P1 General purpose boards for use in dry conditions
- P2 Boards for interior fitments (including furniture) for use in dry conditions
- P3 Non load-bearing boards for use in humid conditions
- P4 Load-bearing boards for use in dry conditions
- P5 Load-bearing boards for use in humid conditions
- P6 Heavy duty load-bearing boards for use in dry conditions
- P7 Heavy duty load-bearing boards for use in humid conditions

## 2.3 Technical Data

Due to the large variability of product properties and quality grades, the table below only shows the range of technical characteristics for classes P1 to P3 (boards for non-structural applications).

Structural boards as well as customized products have different technical characteristics from the ones shown.

| Name | Value | Unit |
|---|---|---|
| Bending strength (longitudinal) according to EN 310 | 5.5 - 15 | $N/mm^2$ |
| E-module (longitudinal) according to EN 310 | 1050 - 2050 | $N/mm^2$ |
| Material dampness at delivery according to EN 322 | 5 - 13 | % |
| Tensile strength rectangular according to EN 319 | 0.14 - 0.45 | $N/mm^2$ |
| Density limit deviation from average value according to EN 323 | +/- 10 | % |
| Strength tolerance according to EN 324 | +/- 0.3 | mm |
| Length and with tolerance according to EN 324 | +/- 5.0 | mm |
| Edge straightness tolerance according to EN 324 | +/- 1.5 | mm/m |
| Perpendicularity according to EN 324 | +/- 2.0 | mm/m |
| Thickness swelling according to EN 317 | 12 - 17 | % |

Performance data of the product in accordance with the declaration of performance with respect to its essential characteristics according to:
*EN 312, Particleboards – Specifications*
*EN 13986+A1, Wood-based panels for use in construction – Characteristics, evaluation of conformity and marking.*

**Declaration of Performance (DoP)**

For more details on technical information, please see the respective products' Declaration of Performance (DoP) available at:
www.sonaearauco.com

Reference technical properties coated particle board according to *EN 14322:2021* are presented in the table below as reference values (special boards, as well as customized products can have different values).

| Property | Unit | Requirements |
|---|---|---|
| Resistance to scratching | N | ≥ 1.5 |
| Resistance to staining | Rating | ≥ 3 |
| Resistance to cracking | Rating | ≥ 3 |
| Abrasion resistance – woodgrains & fantasises | Class 1 | IP < 50 |
| Abrasion resistance – unicolour | Class 3A | IP ≥ 150 |

## 2.4 Delivery status

Coated particleboard ranging in thicknesses from 6 to 40 mm can be purchased as coated boards. The boards are offered in standard formats. Custom formats are also available.

The following table includes typical dimension ranges for the boards supplied worldwide. Some of the combinations for sizes may not be available in all markets.

Thickness: 6 – 40
Width: 600 – 2650
Lenght: 800 – 5700

For updated information on available dimensions, please refer to:
www.sonaearauco.com

## 2.5 Base materials/Ancillary materials

Coated particleboard bonded with urea-formaldehyde/melamine-urea-formaldehyde (UF/MUF) consist of (dimensions as % by mass):

- Wood chips: approx. 85 %
- Water: 4 – 7%
- UF glue / MUF glue (urea resin, melamine urea resin): 8 – 10 %
- Paraffin wax emulsion: <1.5 %
- Impregnated paper: 0.5 – 3 %

Coated particleboard bonded with polymeric diphenylmethane diiscocyanate (PMDI) consist of (dimensions as % by mass):

- Wood chips: approx. 85 %
- Water: 4 – 7 %
- PMDI glue: 8 – 10 %
- Paraffin wax emulsion: < 1.5 %
- Impregnated paper: 0.5 – 3 %

Wood from indigenous, largely regional forest plantations is used for manufacturing particleboard. This wood is typically procured from forests an average radius of 250 km of the plants' locations.

Furthermore, sawmill residues and recycled wood are also used as key raw materials in the production of particleboard.

The entire range can be made available on request as FSC® certified or PEFC (program for the endorsement of forest certification) certified products.

Additionally, the complete range includes CE-marked products.

This product contains substances listed in the *ECHA candidate list* (date: 08.06.2021) exceeding 0.1 percentage by mass: no

This product contains other carcinogenic, mutagenic, reprotoxic (CMR) substances in categories 1A or 1B which are not on the *ECHA candidate list*, exceeding 0.1 percentage by mass: no

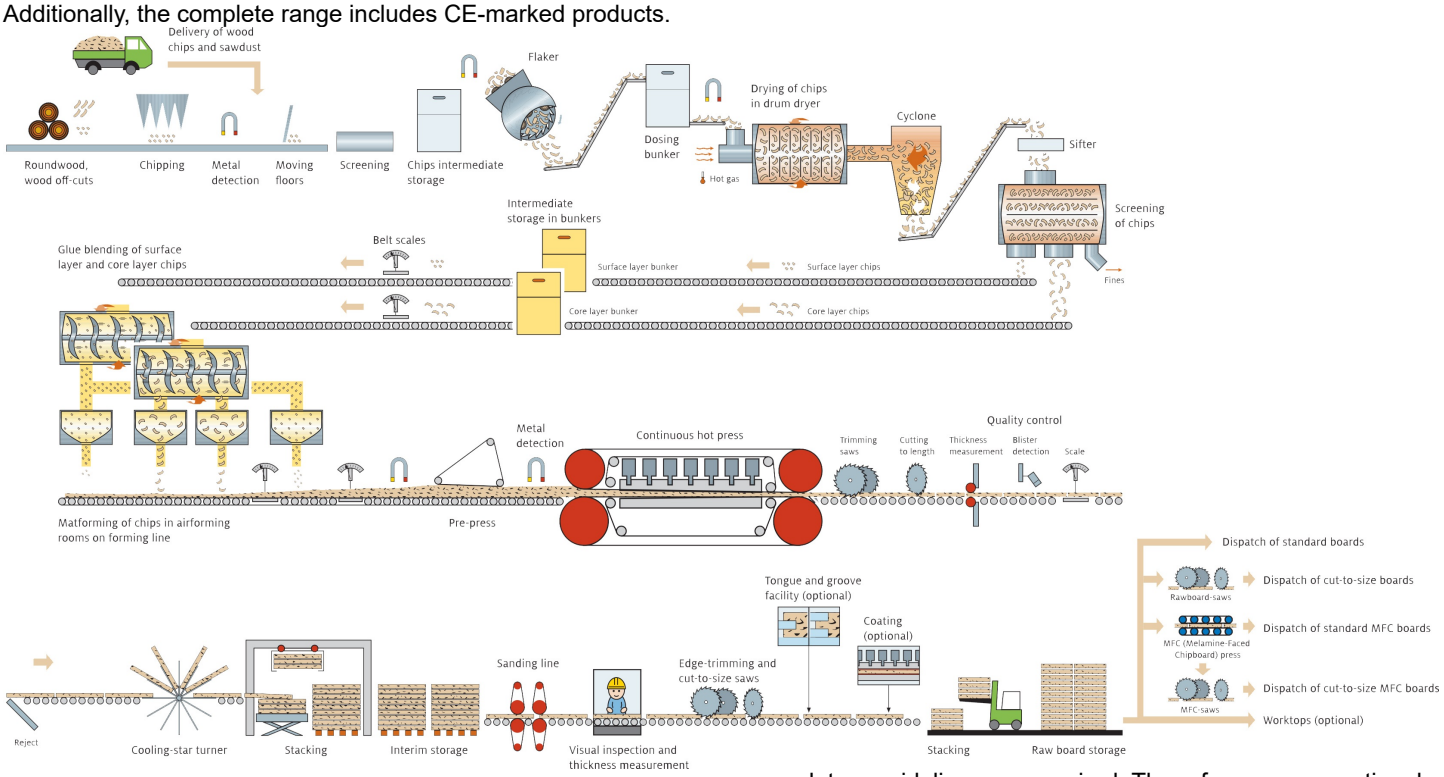
Biocide products were added to this construction product or it has been treated with biocide products (this then concerns a treated product as defined by the (EU) *Ordinance on Biocide Products No. 528/2012*: no

## 2.6 Manufacture

The wood is chipped, screened and dried. Surface layer and core layer materials are then glued and scattered on a forming belt as a particles' mat. This is pressed into panels under high pressure in a hot press. The panels are trimmed, picked and sanded on both sides after cooling.
Finally, the panels are coated with melamine-impregnated paper in a short-cycle press.

All leftovers incurred during board manufacture are redirected into the process or used as fuel to supply the energy needs of the manufacturing process on site.

A process diagram is presented below.




The production sites are certified according to the following standards:

- *ISO 9001*
- *ISO 45001*
- *ISO 50001* (European sites).

## 2.7 Environment and health during manufacturing

***Health protection:*** Due to the manufacturing conditions, no special health protection measures over and beyond the regulatory guidelines are required. The reference occupational exposure limit values are complied with.

***Emissions into air:*** Waste air generated during production is cleaned in accordance with regulatory requirements. Emissions have to comply with the values specified by the operation licenses of the different sites, specified according to national laws.

***Emissions into water/soil:*** No normal process contamination of water or soil exists. Typically, the production process of coated particleboard does not have any

production-related waste water.

***Noise:*** Noise surveys are required and are performed for each site according to respective national regulations. Noise-intensive plant areas such as chipping are encapsulated or protected appropriately by structural measures. Whenever necessary (close to non-encapsulated areas), the use of ear protection is required (PPE, Personal Protective Equipment) within Sonae Arauco sites, as an additional safety measure. The production sites are all *ISO 14001* certified.

### 2.8 Product processing/Installation

Sonae Arauco coated particleboard can be sawn, milled and drilled using standard machinery or (electric) power tools. Carbide-tipped tools should be given preference, especially on circular saws.
Respiratory protection should be worn when using hand-held equipment without suction devices.
Please refer to the respective devices' datasheets for further processing recommendations.

### 2.9 Packaging

Sonae Arauco coated particleboards are supplied on squared timber bound by plastic or metal bands and covered with corrugated cardboard and, on the bottom, with a cover board. Particleboard and steel or PET packing bands for transport packaging can be sorted and directed to the recycling circuits. If re-use or recycling is impractical, the packaging should not be landfilled, but rather directed towards energy recovery. Packaging disposal information is available at: www.sonaearauco.com

### 2.10 Condition of use

The components making up coated particleboard correspond with the base material compositions as outlined in Clause 2.6. During hot pressing, the binding agent is linked irreversibly by means of poly-condensation and firmly bonded with the wood. The binding agents are chemically and stably bound to the wood.
***VOC emissions:*** Sonae Arauco coated particleboards are labelled as class A+ according to the French regulation on the labelling of emissions of volatile pollutants from construction and decoration products (with reference to the wall scenario, as a worst case).

Sonae Arauco particleboard coated with melamine impregnated paper at an average area weight of 11.1 kg/m$^2$ stores 16.5 kg $CO_2$/m$^2$ equivalent over its service life.

### 2.11 Environment and health during use

**Environmental protection:** According to current information, water, air and soil are not exposed to any dangers when the respective products outlined above are used as designated.

**Health protection:** According to current information, no damage to or impairment of health can be anticipated when particleboards are used as designated. With the exception of low volumes of formaldehyde for UF/MUF-bonded particleboard, VOC emissions from products are negligible, and are natural wood ingredients.

### 2.12 Reference service life

Due to the wide range of applications of Sonae Arauco coated particleboard, no reference service life is declared.

### 2.13 Extraordinary effects

**Fire**
Fire retardant classification of coated particleboard is done according to *EN 13986*. Fire retardant classes are defined in accordance with *EN 13501-1*.

**Fire protection**

| Name | Value |
|---|---|
| Building material class | D |
| Smoke gas development | S2 |
| Burning droplets | d0 |

Surfaced particleboard with improved fire reaction is available with, classification B-s2,d0

**Water**
No ingredients are washed out which could be hazardous to water. Particleboards are not resistant to permanent exposure to water.

**Mechanical destruction**
Mechanical destruction of coated particleboards can result in sharp edges on the broken panel edges (risk of injury).

### 2.14 Re-use phase

***Recycling:*** Sonae Arauco coated particleboards from construction can be collected separately and utilised in the manufacture of particleboard. This is based on the condition that the wooden boards are not fully glued.

***Energy recovery***: Due to the high heating value of approx. 16.6 MJ/kg at 20 % moisture content assumed for post-consumer boards, coated particleboards can be used for energy recovery and the generation of heat and electricity (e.g. in CHP plants), following the cascading principle for wood.

### 2.15 Disposal

Sonae Arauco coated particleboard leftovers and residual materials incurred as a result of demolition measures on the building sites should be primarily directed towards material recycling. If this is not possible, they must be directed toward energy recovery instead of landfilling.

Waste code according to the *European List of Waste*: 17 02 01

### 2.16 Further information

Further information such as technical datasheets, etc. can be downloaded under:

www.sonaearauco.com

# 3. LCA: Calculation rules

### 3.1 Declared Unit

The declared unit for the LCA is 1 $m^2$ of average Sonae Arauco particleboard.

**Information on the declared unit**

| Name | Value | Unit |
|---|---|---|
| Declared unit | 1 | $m^2$ |
| Grammage | 11.1 | $kg/m^2$ |
| Layer thickness | 0.0165 | m |

The weighted average was calculated based on production volumes from the plants in all countries where Sonae Arauco was operating in 2021 (some plants 2020).

### 3.2 System boundary

Type of the EPD: cradle-to-gate with modules C1 to C4 and module D (A1-A3, C and D)

*Modules A1 – A3* of the production stage cover the manufacturing of the products, including raw material extraction and processing, energy generation, the production of ancillary products and packaging materials, transport, as well as all waste treatment processes. Eventual benefits of recycling or energy recovery are neglected.

The resource aspects of wood were inventoried via material inherent properties such as resource extraction of $CO_2$ from the atmosphere and the lower heating value as the use of renewable energy. Material inherent properties are subject to co-product allocation as ruled in *EN 15804*.

*Module A4* covers the transport of the product from the production site to the construction site by a lorry over a default distance of 460 km.

*Module A5* covers the transport of the packaging material from the construction site and its disposal. Default end-of-waste states for the packaging materials from the packed products at the construction site are defined in analogy for wastes occurring in modules A1-A3. Eventual further inputs for the installation of the products are not considered due to the broad applicability of the assessed products.
The substituted primary material from the net amount of recycled material and from recovered energy exported from the product system in Module A5 is declared in Module D.

*Module C1* manual deconstruction isassumed. The declared values are thus 0.

*Module C2* includes the transport of the de-constructed product to a recycling centre by over 50 km.

*Module C3* covers the preparation of the post-consumer board to become a secondary fuel; the end-of-waste status for recycled wood-based boards is defined as the point where they have been sorted and chipped, ready to be used as secondary fuels.
In line with *EN 16485*, the export of the biogenic carbon stored in the board, expressed in $CO_2$-equivalent is also reported in module C3.

*Module C4* is not relevant for the assumed end-of-life scenario. The declared values are thus 0.

*Module D* compiles all the benefits and burdens associated with the secondary fuels, secondary materials and exported energy leaving the production system in the modules A5 and C3. Therefore, module D covers the avoided burdens from recycling and from energy recovered from the waste treatment in module A5 as well as the transport of the obsolete boards to a biomass combustion plant, the combustion process itself and the loads and benefits of the substitution of fossil fuels and/or electricity. Substitution effects in module D are always calculated for the net amount of secondary material or secondary fuel of the product system in line with *EN 16485*.

### 3.3 Estimates and assumptions

For the quantification of the net flows of recycled wood (input of post-consumer wood used as a fuel minus post-consumer wood exiting the product system into module D for energy recovery), it was assumed that all inputs of post-consumer wood are used as a fuel; inputs of post-consumer wood beyond the need of wood fuel used in production was considered to be used as a recycled material input. Beyond that, no relevant estimates or assumptions had to be made beyond the information provided in this EPD.

### 3.4 Cut-off criteria

All data were taken into account that resulted from the data collection procedure in the plants, e.g. related to fuels, raw material input, use of ancillary materials, waste flows, emissions into the air, water use, waste water, transport means and transport distances, etc..
Expenses for the general management, research & development, administration and marketing – if known – were not taken into account.

The production of eventual packaging of ancillary material or other inputs used during production (and some of the reported wastes) were generally neglected; in most cases reusable bins or containers are used. In addition, the amounts of reported (unspecific) wastes are so small that their production can be considered not relevant for the life cycle assessment. Additional plant specific information can be found in the respective chapters for each plant.

Beyond that some plants reported ancillary materials that were cut off due to very small amounts and as inputs not directly related to production processes but to the maintenance of infrastructure, e.g. acetylene and oxygen for soldering, etc. With this approach mass and energy flows below 1 percent of total mass and energy flows caused by the declared products were included in the assessment.

Beyond that, no material or energy flows were neglected that would have been known by the persons responsible for the project and that could have been expected to contribute significantly to the environmental indicators declared. It can thus be assumed that the total contribution of the neglected processes is not higher than 5 % of the declared impact categories.

### 3.5 Background data

Datasets from *ecoinvent 3.8* were used as background data exclusively. Therefore, the latest update of the background data took place in 2021.

### 3.6 Data quality

The requirements on the data quality and the background data correspond to the
provisions in *EN 15804*:

- Data are as current as possible. Datasets used for calculations were updated within the last 10 years for

generic data and within the last 5 years for producer-specific data;
- Datasets are based on 1-year averaged data as a general rule;
- The time period over which inputs to and outputs from the system are accounted for is 100 years from the year for which the data set is deemed representative;
- The technological coverage reflects the physical reality of the declared products;
- The background datasets comply with the quality guidelines of *ecoinvent v.3*; deviations from the methodological prescriptions of EN *15804* cannot be excluded but are considered not significant in the context of this EPD.

### 3.7 Period under review

The company data gathered for this EPD represents the year 2021 (for some plants 2020).

### 3.8 Geographic Representativeness

Land or region, in which the declared product system is manufactured, used or handled at the end of the product´s lifespan: Europe

### 3.9 Allocation

The inventories for the wood inputs were taken from *ecoinvent v.8*. In ecoinvent, the forestry processes are modelled on a mass-basis and sawmilling processes are allocated based on revenues of the different co-products of a joint co-production process.
Waste generated by edge-trimming and cut-size saws is used internally for energy generation. Some plants sell minor quantities of bark, waste wood or electricity from co-generation. No impacts are allocated to these outputs.
Biogenic carbon (content) is modelled manually thus reflects the real physical flows; this is not the case for primary energy, implying that the content of primary energy in products and packaging is allocated as the main inputs/outputs of a unit process.
In the case of sites where several products were produced and no product-specific information was available, all inputs and outputs related to production processes were attributed based on a total mass of production; packaging material was attributed based on a total volume of the production. Inputs and outputs for coating processes that could not be separated from the data on plant level were conservatively attributed to the particleboard production.
Post-consumer secondary wood is used as an input to produce particleboard; for this input as well as for the end-of-life scenario, the end-of-waste status was defined after the sorting and chipping of the wood-based board in line with *EN 16485* (see also clause 3.2). In analogy, particleboard leaving the product system at the end-of-life is considered a secondary fuel; its combustion and the benefits of energy recovery are declared in module D.
Waste packaging in module A5 was considered not to reach the end-of-waste state as a fuel. Its incineration is reported in A5, the benefits of energy recovery in module D. The benefits of the recycling of minor amounts of packaging materials are disregarded.
No co-product allocation was made in the modelling of the foreground data of the life cycle assessment underlying this EPD.

### 3.10 Comparability

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to *EN 15804* and the building context, respectively the product-specific characteristics of performance, are taken into account.
Datasets from *ecoinvent v3.8* were used as background data exclusively.

## 4. LCA: Scenarios and additional technical information

**Characteristic product properties of biogenic carbon**
Note: 1 kg of biogenic carbon is equivalent to 44/12 kg of $CO_2$.

**Information on describing the biogenic carbon content at factory gate**

| Name | Value | Unit |
|---|---|---|
| Biogenic carbon content in product | 4,50 | kg C |
| Biogenic carbon in packaging | 0,0540 | kg C |

The following technical information is a basis for the declared modules or can be used for developing specific scenarios in the context of a building assessment if modules are not declared (MND).

**Transport to the construction site (A4)**
The product is transported from the production site to the construction site by a lorry (15 % emissions class EURO 5; 85 % emissions class EURO 6) over a default distance of 460 km.

**Installation into the building (A5)**
Eventual further inputs for the installation of the products are not considered due to the broad applicability of the assessed products.
An average transport distance of 30 km was assumed for packaging waste from the construction site to the recycling plant or to the municipal waste incineration plant. The municipal waste incineration plant is assumed to have an overall energy efficiency of 53 % related to the lower heating value of the waste input; 92 % of the recovered energy is heat, 8 % is electricity (according to specifications of MWI plants in *ecoinvent 3.8*).

**Deconstruction(C1)**
Manualdeconstruction is assumed. The declared values are thus 0.

**Transport to waste treatment (C2)**
This module includes the transport of the de-constructed product to a recycling centre by a lorry (15 % emissions class EURO 5; 85 % emissions class EURO 6) by over 50 km.

**Waste treatment (C3)**
12.1 kg of coated particleboard are chipped and exported from the product life cycle into module D, assuming a moisture content of 20 % and a lower heating value of 16,2 MJ/kg.
The biogenic carbon stored in the product and the content of primary energy are exported from the product system as material inherent properties.

**Disposal (C4)**
This module is not relevant for the assumed end-of-life scenario. The declared values are thus 0.

**Reuse, recycling, recovery potential (D)**
According to default assumptions in other IBU EPDs, post-consumer wood is used as a secondary fuel for energy recovery in a biomass combustion plant with an overall energy efficiency of 93 % related to the lower heating value of the fuel input; 91 % of the recovered energy is heat, 9 % is electricity.

## 5. LCA: Results

**DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE OR INDICATOR NOT DECLARED; MNR = MODULE NOT RELEVANT)**

| Product stage | | | Construction process stage | | Use stage | | | | | | | End of life stage | | | | Benefits and loads beyond the system boundaries |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Raw material supply | Transport | Manufacturing | Transport from the gate to the site | Assembly | Use | Maintenance | Repair | Replacement | Refurbishment | Operational energy use | Operational water use | De-construction demolition | Transport | Waste processing | Disposal | Reuse-Recovery-Recycling-potential |
| **A1** | **A2** | **A3** | **A4** | **A5** | **B1** | **B2** | **B3** | **B4** | **B5** | **B6** | **B7** | **C1** | **C2** | **C3** | **C4** | **D** |
| X | X | X | X | X | MND | MND | MNR | MNR | MNR | MND | MND | X | X | X | X | X |

**RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: Particleboard, coated with melamine-impregnated paper, per m²**

| Parameter | Unit | A1-A3 | A4 | A5 | C1 | C2 | C3 | C4 | D |
|---|---|---|---|---|---|---|---|---|---|
| GWP-total | kg $CO_2$ eq | -9.11E+00 | 8.43E-01 | 2.11E-01 | 0 | 1.18E-01 | 1.66E+01 | 0 | -5.17E+00 |
| GWP-fossil | kg $CO_2$ eq | 7.57E+00 | 8.43E-01 | 1.26E-02 | 0 | 1.18E-01 | 9.83E-02 | 0 | -5.17E+00 |
| GWP-biogenic | kg $CO_2$ eq | -1.67E+01 | 0 | 1.98E-01 | 0 | 0 | 1.65E+01 | 0 | 0 |
| GWP-luluc | kg $CO_2$ eq | 1.16E-02 | 3.36E-04 | 7.4E-07 | 0 | 5.6E-05 | 2.25E-04 | 0 | -3.22E-03 |
| ODP | kg CFC11 eq | 1.08E-06 | 1.95E-07 | 1.05E-09 | 0 | 2.67E-08 | 4.93E-09 | 0 | -1.18E-06 |
| AP | mol $H^+$ eq | 4.72E-02 | 2.55E-03 | 6.04E-05 | 0 | 3.56E-04 | 5.24E-04 | 0 | -9.14E-03 |
| EP-freshwater | kg P eq | 2.86E-04 | 5.99E-06 | 2.55E-08 | 0 | 9.67E-07 | 1.02E-05 | 0 | -1.43E-04 |
| EP-marine | kg N eq | 8.12E-03 | 5.59E-04 | 2.72E-05 | 0 | 7.46E-05 | 7.12E-05 | 0 | -9.59E-04 |
| EP-terrestrial | mol N eq | 1.1E-01 | 6.21E-03 | 3.07E-04 | 0 | 8.31E-04 | 8.14E-04 | 0 | -1.08E-02 |
| POCP | kg NMVOC eq | 3.02E-02 | 2.25E-03 | 9.1E-05 | 0 | 3.02E-04 | 2.29E-04 | 0 | -4.71E-03 |
| ADPE | kg Sb eq | 8.93E-05 | 2.98E-06 | 7.4E-09 | 0 | 5.42E-07 | 2.7E-07 | 0 | -3.27E-06 |
| ADPF | MJ | 1.49E+02 | 1.28E+01 | 6.73E-02 | 0 | 1.77E+00 | 2.05E+00 | 0 | -1.55E+02 |
| WDP | $m^3$ world eq deprived | 8.27E+00 | 3.88E-02 | 3.58E-04 | 0 | 5.88E-03 | 2.38E-02 | 0 | -1.41E-01 |

GWP = Global warming potential; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential of land and water; EP = Eutrophication potential; POCP = Formation potential of tropospheric ozone photochemical oxidants; ADPE = Abiotic depletion potential for non-fossil resources; ADPF = Abiotic depletion potential for fossil resources; WDP = Water (user) deprivation potential)

**RESULTS OF THE LCA - INDICATORS TO DESCRIBE RESOURCE USE according to EN 15804+A2: Particleboard, coated with melamine-impregnated paper, per m²**

| Parameter | Unit | A1-A3 | A4 | A5 | C1 | C2 | C3 | C4 | D |
|---|---|---|---|---|---|---|---|---|---|
| PERE | MJ | -9.99E+01 | 1.79E-01 | 2.14E+00 | 0 | 2.95E-02 | 3.56E-01 | 0 | -5.13E+00 |
| PERM | MJ | 1.73E+02 | 0 | -2.14E+00 | 0 | 0 | -1.71E+02 | 0 | 0 |
| PERT | MJ | 7.32E+01 | 1.79E-01 | 7.64E-04 | 0 | 2.95E-02 | -1.71E+02 | 0 | -5.13E+00 |
| PENRE | MJ | 1.22E+02 | 1.28E+01 | 1.73E-01 | 0 | 1.77E+00 | 2.07E+00 | 0 | -1.54E+02 |
| PENRM | MJ | 2.73E+01 | 0 | -1.06E-01 | 0 | 0 | -2.72E+01 | 0 | 0 |
| PENRT | MJ | 1.49E+02 | 1.28E+01 | 6.73E-02 | 0 | 1.77E+00 | -2.51E+01 | 0 | -1.54E+02 |
| SM | kg | 2.69E+00 | 0 | 0 | 0 | 0 | 0 | 0 | 0 |
| RSF | MJ | 6.92E+01 | 0 | 0 | 0 | 0 | 0 | 0 | 1.05E+02 |
| NRSF | MJ | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 3.37E+01 |
| FW | $m^3$ | 2.15E-01 | 1.35E-03 | 5.67E-05 | 0 | 5.67E-05 | 1.25E-03 | 0 | -1.18E-02 |

PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials; PENRT = Total use of non-renewable primary energy resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water

**RESULTS OF THE LCA – WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A2: Particleboard, coated with melamine-impregnated paper, per m²**

| Parameter | Unit | A1-A3 | A4 | A5 | C1 | C2 | C3 | C4 | D |
|---|---|---|---|---|---|---|---|---|---|
| HWD | kg | 2.07E-04 | 3.33E-05 | 5.34E-08 | 0 | 4.75E-06 | 9.52E-07 | 0 | -1.67E-04 |
| NHWD | kg | 1.57E+00 | 6.71E-01 | 1.67E-03 | 0 | 7.59E-02 | 1.36E-02 | 0 | 1.86E-01 |
| RWD | kg | 6.6E-04 | 1.85E-04 | 9.09E-07 | 0 | 2.54E-05 | 2.68E-05 | 0 | -4.82E-04 |
| CRU | kg | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 |
| MFR | kg | 1.29E-02 | 0 | 5.59E-03 | 0 | 0 | 0 | 0 | 0 |
| MER | kg | 0 | 0 | 0 | 0 | 0 | 1.21E+01 | 0 | 0 |
| EEE | MJ | 4.48E-04 | 0 | 7.63E-02 | 0 | 0 | 0 | 0 | 0 |
| EET | MJ | 5.15E-03 | 0 | 8.77E-01 | 0 | 0 | 0 | 0 | 0 |

HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed; CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported electrical energy; EET = Exported thermal energy

**RESULTS OF THE LCA – additional impact categories according to EN 15804+A2-optional: Particleboard, coated with melamine-impregnated paper, per m²**

| Parameter | Unit | A1-A3 | A4 | A5 | C1 | C2 | C3 | C4 | D |
|---|---|---|---|---|---|---|---|---|---|
| PM | Disease incidence | 3.82E-07 | 5.4E-08 | 8.48E-10 | 0 | 6.52E-09 | 1.6E-09 | 0 | -7.12E-09 |
| IR | kBq U235 eq | 3.02E-01 | 5.55E-02 | 2.67E-04 | 0 | 7.71E-03 | 1.81E-02 | 0 | -2.79E-01 |
| ETP-fw | CTUe | 1.76E+02 | 1E+01 | 5.54E-02 | 0 | 1.45E+00 | 1.16E+00 | 0 | -9.58E+00 |
| HTP-c | CTUh | 4.99E-08 | 3.22E-10 | 3.28E-11 | 0 | 5.23E-11 | 5.51E-11 | 0 | 1.28E-09 |
| HTP-nc | CTUh | 1.3E-07 | 1.02E-08 | 1.22E-10 | 0 | 1.41E-09 | 9.99E-10 | 0 | 2.5E-09 |
| SQP | SQP | 3.78E+02 | 8.88E+00 | 1.34E-02 | 0 | 1.05E+00 | 3.16E-01 | 0 | -4.05E+00 |

PM = Potential incidence of disease due to PM emissions; IR = Potential Human exposure efficiency relative to U235; ETP-fw = Potential comparative Toxic Unit for ecosystems; HTP-c = Potential comparative Toxic Unit for humans (cancerogenic); HTP-nc = Potential comparative Toxic Unit for humans (not cancerogenic); SQP = Potential soil quality index

Disclaimer 1 – for the indicator "Potential Human exposure efficiency relative to U235". This impact category deals mainly with the eventual impact of low-dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure or radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, radon and from some construction materials is also not measured by this indicator.

Disclaimer 2 – for the indicators "abiotic depletion potential for non-fossil resources", "abiotic depletion potential for fossil resources", "water (user) deprivation potential, deprivation-weighted water consumption", "potential comparative toxic unit for ecosystems", "potential comparative toxic unit for humans – cancerogenic", "Potential comparative toxic unit for humans - not cancerogenic", "potential soil quality index". The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high as there is limited experience with the indicator.

## 6. LCA: Interpretation

Figure 1 illustrates the contribution of each life cycle stage to the overall indicator results of the impact assessment (impact from module A1-C4 = 100 %) for coated particleboard.

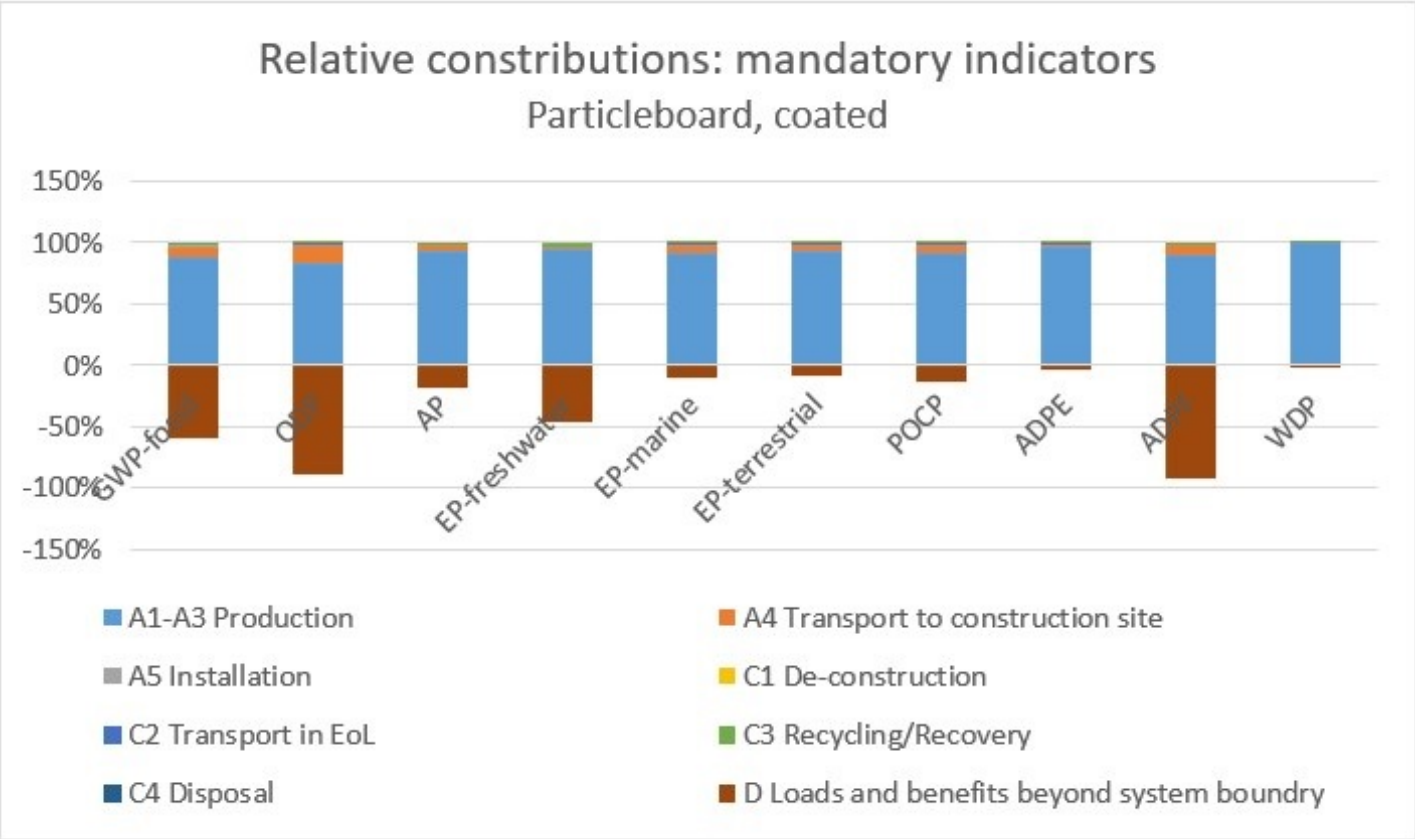



**Figure 1: Environmental impacts of particleboard coated with melamine-impregnated paper along its life cycle (impacts from production modules A1-C4 = 100 %)**

Figure 1 illustrates that the environmental profile of coated particleboard is dominated by the production phase (modules A1-A3). Minor contributions stem from transport to the construction site whereas the contributions from other modules of the life cycle are negligible.
Loads and benefits beyond the life cycle (module D) are negative (benefits > loads) whereas major contributions occur for the ODP, the GWP-fossil and for the ADPF; these benefits basically stem from the use of the particleboard as secondary fuel and its related substitution of natural gas and electricity from the grid from the recovered energy.

Figure 2 illustrates that the biogenic carbon stored in the particleboard coated with melamine im-pregnated paper, expressed as $CO_2$-equivalent, is higher than the $CO_2$ emissions from fossil sources, leading to a negative GWP for the production module A1-A3. The potential substitution effect in mod-ule D offsets the GHG emissions during the production phase (module A1-A3).

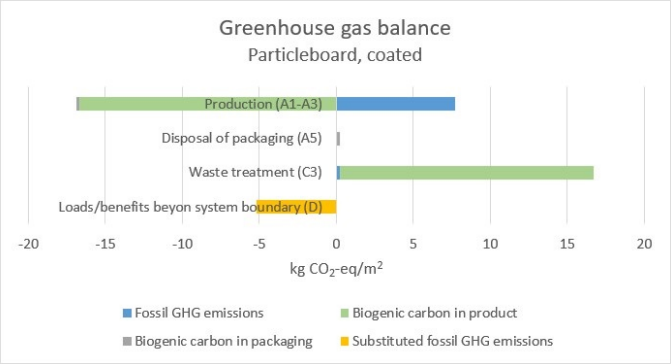



**Figure 2: Greenhouse Gas balance of particleboard coated with melamine-impregnated paper**

The GWP is dominated by $CO_2$ emissions and removals.

## 7. Requisite evidence

### 7.1 Formaldehyde

For UF/MUF bonded boards:
(tests made on raw boards)

**Measuring agency**: MPA Eberswalde materialprüfanstalt Brandenbutg GmbH - Holz uns Holzschutz
**Test report, date**: No 31/23/4155/01/QT issued at 02.04.2023
**Result**: ZE05 - Certification of wood-based panels regarding formaldehyde emissions in accordance with the German Chemicals Prohibition Ordinance (*ChemVerbotsV*) and based on *DIBt Guideline 100*. Test procedure according to *EN 717-1*. Calculated formaldehyde concentration was 0,054 ppm according to *ChemVerbotsV* (concentration of EN 717-1 multiplied by factor 2), compying with the limit 0,1ppm.

**Measuring agency**: MPA Eberswalde materialprüfanstalt Brandenbutg GmbH - Holz uns Holzschutz
**Test report, date**: No. 31/23/3768/01/QT issued on the 25.01.2023
**Result**: ZE05 - Certification of wood-based panels regarding formaldehyde emissions in accordance with the German Chemicals Prohibition Ordinance (*ChemVerbotsV*) and based on *DIBt Guideline 100*. Test procedure according to *EN 717-1*. Calculated formaldehyde concentration was 0,045 ppm according to *ChemVerbotsV* (concentration of *EN 717-1* multiplied by factor 2), compying with the limit 0,1ppm

**Measuring agency**: Fraunhofer Institute for Wood Research Wilhelm-Klauditz-Institut WKI
**Test report, date**: No. QA-2021-0453 issued on the 04.03.2021
**Results**: Determination of the formaldehyde release according to *JIS A1460*. An average value of 0,1 mg/litre was determined with individual values of 0,06 mg/litre and 0,09 mg/litre corresponding to the F4Stars level.

### 7.2 Checking for the pretreatment of the substances used

(tests made on raw boards)
**Measuring agency**: TÜV Rheinland LGA Products GmbH, Cologne, Germany
**Test reports, date**: Report 0001122970/20 AZ 581067, 20.09.2022
**Result**: The limit values are complied with. Limits evaluated according to the *Toy safety-directive 2009/48/EC*: category 3: Scraped of toy material.

Metal analysis for Iberian market, based on quarterly analysis:
**Measuring agency**: IDIT, Instituto de Desenvolvimento e Inovação Tecnológica, Portugal
**Test reports, date**: 2057/2015 & 2058/2015, 22 December 2015
**Result**: The limit values outlined in the EPF voluntary standards on the use of recycled wood are complied with. Limit values in mg/kg: As 25, Pb 90, Cd 50, Cr 25, Cu 40, Hg 25, Cl 1000, F 100, PCP 5 and Creosote 0.5. .

### 7.3 TVOC emissions

**Measuring agency:** Eurofins Denmark
**Test report, date:** 392-2002-00522601-B-EN, issued on the 05.01.2023
**Result:** Classification A+ according to French regulation Decrée of March 2011 (DEVL1101903D) and Arrêté of April 2011 (DEVL1104875A) modified in February 2012 (DEVL1133129A)
Compliant with ABG/AgBB (Ausschuss zur gesundheitlichen Bewertung von Bauprodukten (June 2021).

**AgBB overview of results (28 days)**

| Name | Value | Unit |
|---|---|---|
| TVOC (C6 - C16) | 80 | µg/m$^3$ |
| Sum SVOC (C16 - C22) | < 5 | µg/m$^3$ |
| R (dimensionless) | 0.11 | - |
| VOC without NIK | < 5 | µg/m$^3$ |
| Carcinogenic Substances | < 1 | µg/m$^3$ |

**AgBB overview of results (3 days [µg/m³])**

| Name | Value | Unit |
|---|---|---|
| TVOC (C6 - C16) | 20 | µg/m³ |
| Sum SVOC (C16 - C22) | < 5 | µg/m³ |
| R (dimensionless) | 0.15 | - |
| VOC without NIK | < 5 | µg/m³ |
| Carcinogenic Substances | < 1 | µg/m³ |

**7.4 PCP/Lindane**
(tests made on raw boards)
**Measuring agency**: EPH Entwicklungs- und Prüflabor Holztechnologie GmbH, Zellescher Weg 24, D-01217 Dresden
**Test reports, date:** Standard product Supervision Report 02-2015, Order 2515024/3-2, dated 18 December 2015. P3 product Supervision Report 02-2015, Order 2515024/3-1, dated 18 December 2015
**Result:** The wood preservative agents pentachlorophenol (PCP) and lindane could not be determined in the sample of boards examined, or fulfilled the limit value of 5 mg/kg.
Limit of determination: 0.05 mg/kg.

## 8. References

**Product category rules of IBU**

**IBU (2021)**
IBU (2021): General Instructions for the EPD Programme of the Institut Bauen und Umwelt e.V. (General Instructions for the IBU EPD Programme). Version 2.0, Institut Bauen und Umwelt, Berlin.

**IBU (2021)**
IBU (2021): PCR Part A: Calculation rules for the life cycle assessment and requirements for the project report according to EN 15804+A2:2019. Version 1.3., Institut Bauen und Umwelt, Berlin.

**IBU (2023)**
IBU (2023): PCR Part B: Requirements on the EPD for wood-based panels. Version 2023/04, Institut Bauen und Umwelt, Berlin.

**Standards and legal documents**

**EN 310**
EN 310:1993, Wood-based panels – Determination of modulus of elasticity in bending and of bending strength.

**EN 312**
EN 312:2010, Particleboards – Specifications.

**EN 317**
EN 317:1993, Particleboards and Fibreboards – Determination of swelling in thickness after immersion in water.

**EN 319**
EN 319:1993, Particleboards and fibreboards – Determination of tensile strength perpendicular to the plane of the board.

**EN 322**
EN 322:1993, Wood-based panels – Determination of moisture content.

**EN 323**
EN 323:1993, Wood-based panels – Determination of density.

**EN 324**
EN 324-1:1993, Wood-based panels – Determination of dimensions of boards – Determination of thickness, width and length.
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**EN 717-1**
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**EN 13986**
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**EN 14322**
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**EN 15804**
EN 15804+A2:2019 + AC:2021, Sustainability of construction works – Environmentalproduct declarations – Core rules for the product category construction products.

**EN 16485**
EN 16485:14-07, Round and sawn timber – Environmental Product Declarations –
Product category rules for wood and wood-based products for use in construction.

**ISO 9001**
ISO 9001:2015, Quality management systems – Requirements.

**ISO 14001**
ISO 14001:2015, Environmental management systems – Requirements with guidance for use.

**ISO 14025**
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**ISO 14044**
EN ISO 14044:2006-07, Environmental management - Life cycle assessment - Requirements and guidance (ISO 14044:2006); German and English versions EN ISO 14044:2006.

**ISO 45001**
DIN ISO 45001:2018-06, Occupational health and safety management systems – Requirements with guidance for use.

**ISO 50001**
ISO 50001:2018, Energy management systems – Requirements with guidance for use.

**ISO 16000**
ISO 16000-11:2006, Indoor air – Part 11: Determination of the emission of volatile organic compounds from building products and furnishing – Sampling, storage of samples and preparation of test specimens.

**JIS A 1460**
JIS A 1460:2015: Determination of the emissions of formaldehyde from building boards – Desiccator method.

**ECHA-List**
The Candidate List of substances of very high concern, available via
https://echa.europa.eu/nl/-/four-newsubstances-added-to-the-candidate-list.

**Regulation on biocidal products**
REGULATION (EU) No 528/2012 OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 22 May 2012 concerning the making available on the market and use of biocidal products.

**Regulation (EU) Nr. 305/2011(CPR)**
REGULATION (EU) No 305/2011 OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 9 March 2011 laying down harmonised conditions for the marketing of construction products and
repealing Council Directive 89/106/EEC.

**Toy safety-directive 2009/48/EC**
Directive 2009/48/EC of the European Parliament and of the Council of 18 June 2009 on the safety of toys (Text with EEA relevance).

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COUNCIL REGULATION (EU) No 333/2011 of 31 March 2011 establishing criteria determining when certain types of scrap metal cease to be waste under Directive 2008/98/EC of the European Parliament and of the Council.

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Chemikalien-Verbotsverordnung (German Regulation on the Prohibition of Chemicals, from 14 October 1993).

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https://www.nachhaltigesbauen.de/fileadmin/pdf/Nutzungsdauer_Bautei
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